

Date Thursday, 16/08/2007 11:32:04 AM
User Linda Lacelle

Process Sheet

split
8/11/27

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 34017 - 2
Estimate Number : 11030
P.C. Number : N/A
This Issue : 16/08/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : PURCHASED PARTS
Previous Run : 33589
Written By : 4
Checked & Approved By : 4
Comment : Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM

Drawing Name : BRACKET ASSEMBLY
Part Number : D2803042
Drawing Number : D2803 REV B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 05/09/2007
Qty: 20 Um: Each

19
17

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D28032 STA 84 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
STA 84 BRACKET

Pick:

Qty	Part Number	Description	Batch
1	D2803-2	Bracket	34032

SQ

2.0 D28052 Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
STOP

Pick:

Qty	Part Number	Description	Batch
1	D2805-2	Stop	34033

SQ

3.0 D2809 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
Bushing

Pick:

Qty	Part Number	Description	Batch
1	D2809	Bushing	30749

8/11/3 SQ (17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 11:32:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 34017

Part Number: D2803042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2805-2 into arm as per Dwg D2803

SAD 08-01-03 17

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5 08/01/03 (17)

6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 106377

BP 08-01-07

(17)

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. 08/01/07 (17X)

8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803

mf 08-01-07 (17)

9.0	AN3C16A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	M105426

50

10.0	MS210433	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21043-3	Nut	105792

*25 34

8/1/3 50 (17X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 08/01/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 11:32:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 34017

Part Number: D2803042

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 80.0000 Each(s)

Washer

Pick:

Qty Part Number Description

4 NAS1515H3 Washer

A/R LPS-3 Corrosion Spray

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

Batch (4x) 27
105164
M104929

41
106431

8/1/08 50 (17)

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2803.

mf

8-1-7 (17)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/01/07 (17)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST

148

88 08/01/08 (17)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/09

Job Completion



08/01/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

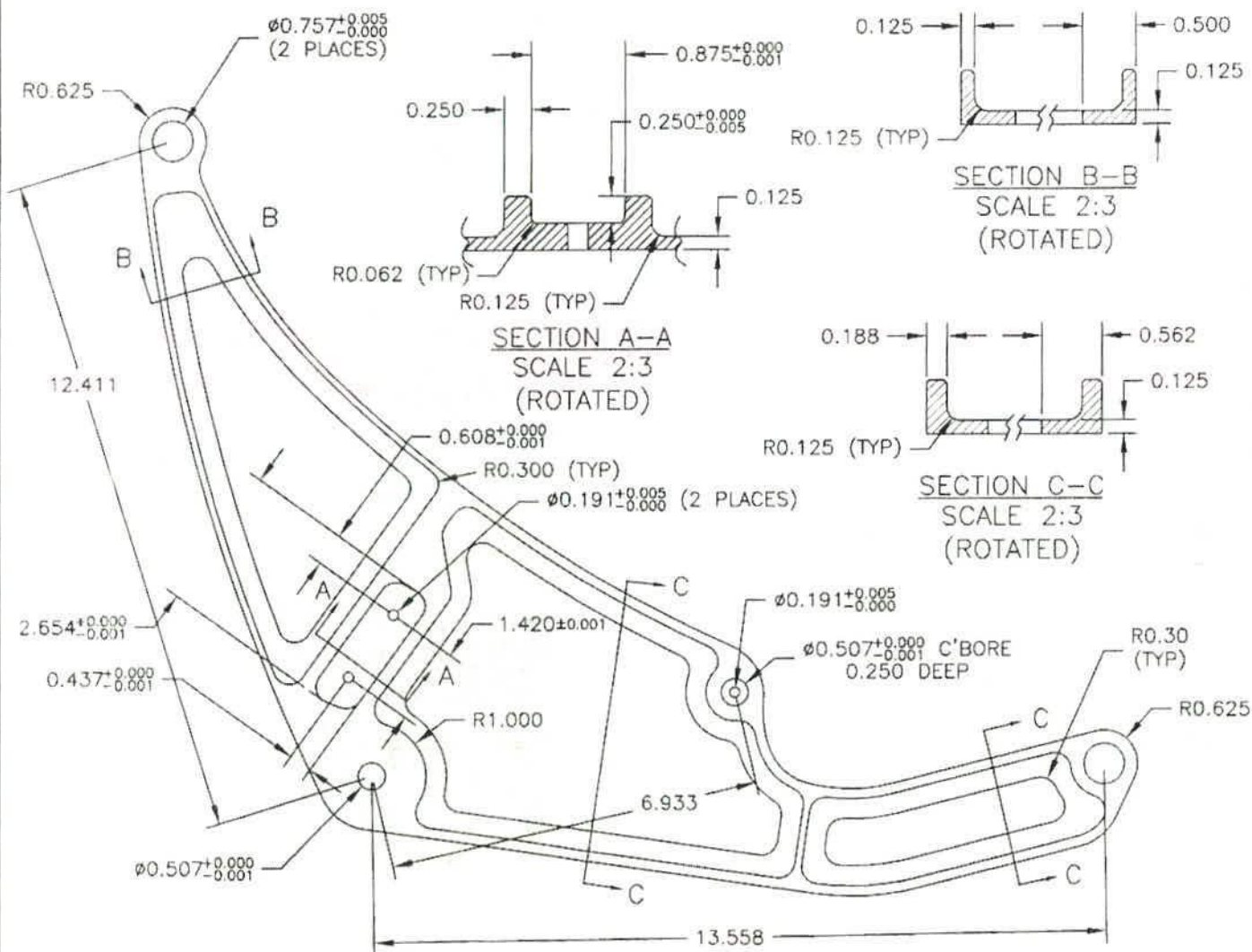
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05-03-11



4/0 34017

D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

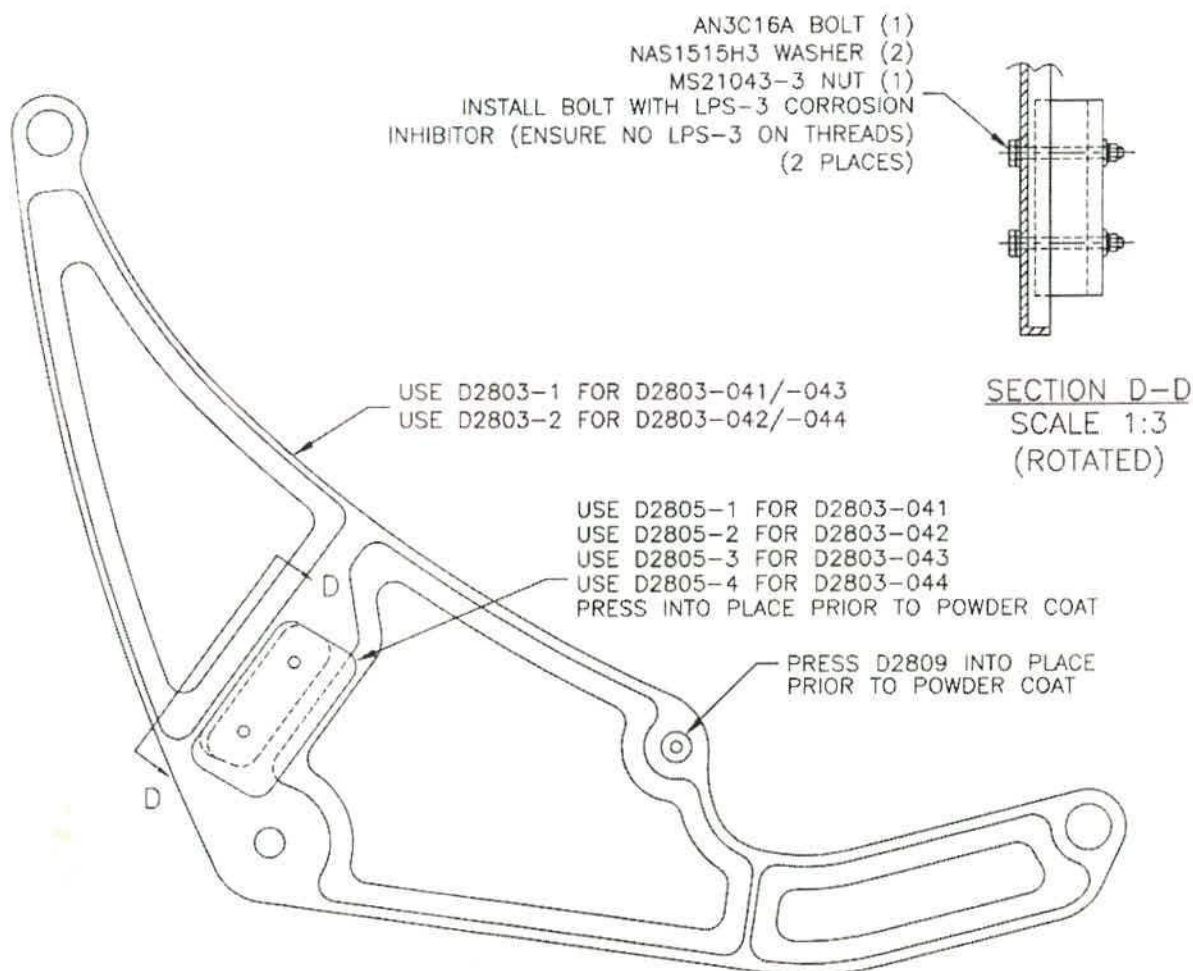
- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



RELEASED

05 03.11

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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